

Work Order ID 76048

76048

ASAP

Page 1

Thursday, November 03, 2011 12:38:23 PM

Item ID: D4095-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 11/4/2011 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 11/9/2011 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: cmf Date: 11-11-03 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-3)								
304, 063	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B11-11-4

(C)

B11-11-4

(x6)

8/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76048***76048***

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Thursday, November 03, 2011 12:38:23 PM

Item ID: D4095-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 11/4/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/9/2011 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00 0.00				(6)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D4095	0.00 0.00				(140)			
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch 9615 Large Fab Memo	0.00 0.00				4		JBL 11-11-23	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76048

Thursday, November 03, 2011 12:38:23 PM

N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp. Stamp

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

QC

Memo

0.00

Quality Control

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 118662 11/11/24 11/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 76048***76048***

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Thursday, November 03, 2011 12:38:23 PM

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Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 11/4/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/9/2011 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							45 11-11-25 (x4)
Quality Control									
200	Identify as per dwg & Stock Location: <u>SFP</u>	0.00							
200									
Packaging	Memo	0.00							(4X) 8p 11-11-25.
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							11/11/28 [Signature]
Quality Control									

MF
11-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 03, 2011 12:38:23 P

Page 1

Work Order ID: 76048

Parent Item: D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 11/4/2011

Required Date: 11/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	164.9000	2.275	14.368421			

B11-11-4

Location

Loc Qty

Loc Code

MAT020

164.9

119346

164.9

119346

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76048
Description: WEAR PLATE ASSEMBLY	Part Number: D4095-043
Inspection Dwg: D4095-3, Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

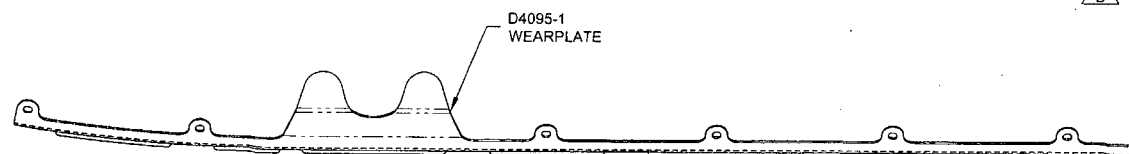
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .19	+ .005 - .001	.191	2		V BO2	
.300	± .010	.303	2		V	
.306	± .010	.304	2		V	
2.432	± .010	2.439	2		V	
3.227	± .010	3.222	2		V	
4.06	± .030	4.055	2		V	
2.56	± .030	2.497	2		V	
4.98	± .030	4.982	1		V	
8.43	± .030	8.424	2		PROW 502	
11.50	± .030	11.50			T BO1	
21.750	± .010	21.750	2		T	
3.500	± .010	3.500	2		T	
12.22	± .030	12.22	2		T	
6.000	± .010	6.000	1		T	
12.100	± .010	12.100	2		T	
21.00	± .030	21.000	2		T	
30.000	± .010	30.000	2		T	
36.000	± .010	36.000	2		T	
38.88	± .030	38.88	2		T	
.063	± .010	.061	2		V	

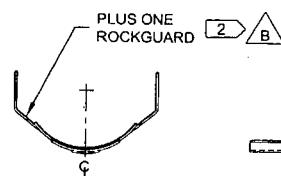
Measured by: B	Audited by: S	Prototype Approval:
Date: 11-11-4	Date: 11/11/07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



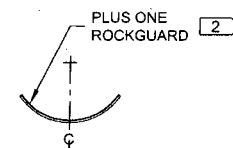
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	J	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 1 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

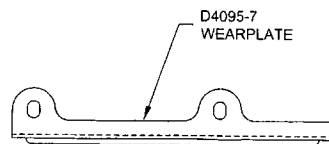
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

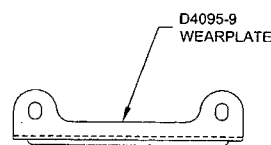
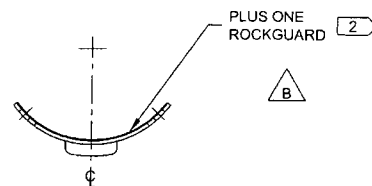
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

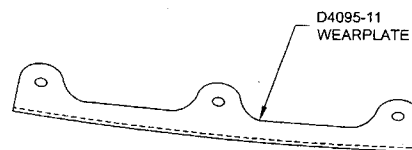
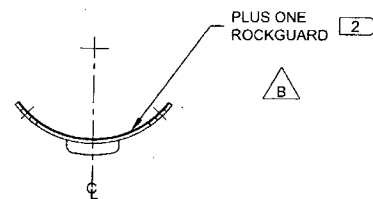
NOTE: Date & initial all entries



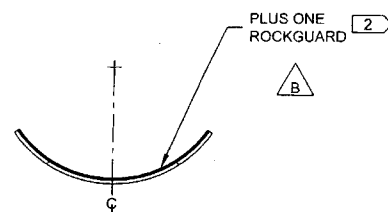
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



76048

RELEASED
2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 2 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE	NTS
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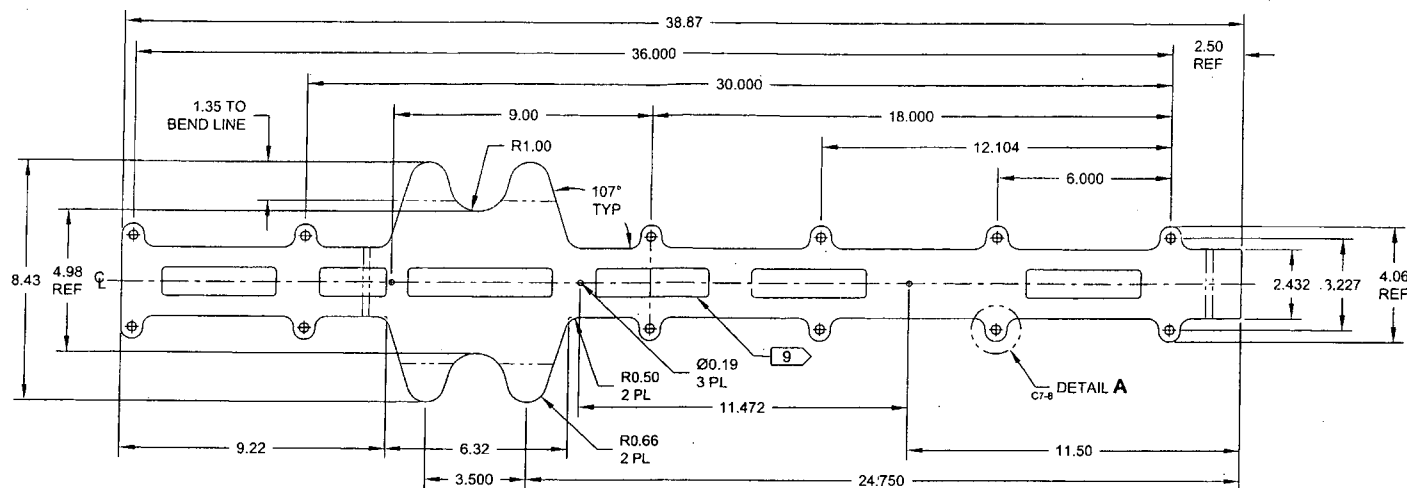
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

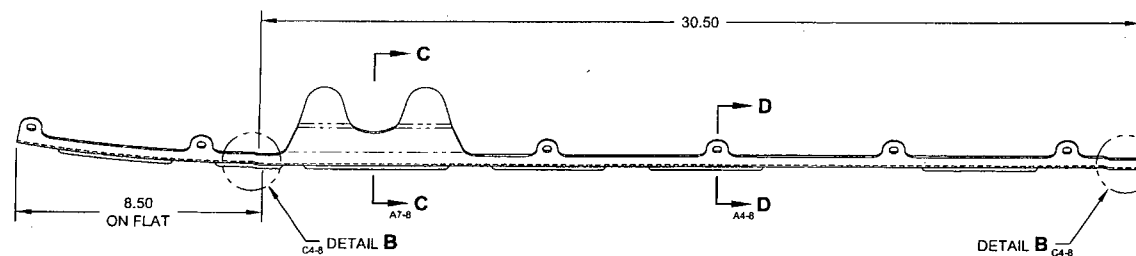
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



 D4095-1F FLAT PATTERN 1



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>140</i>	D4095	SHEET 3 OF 8
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	WEARPLATE	NTS
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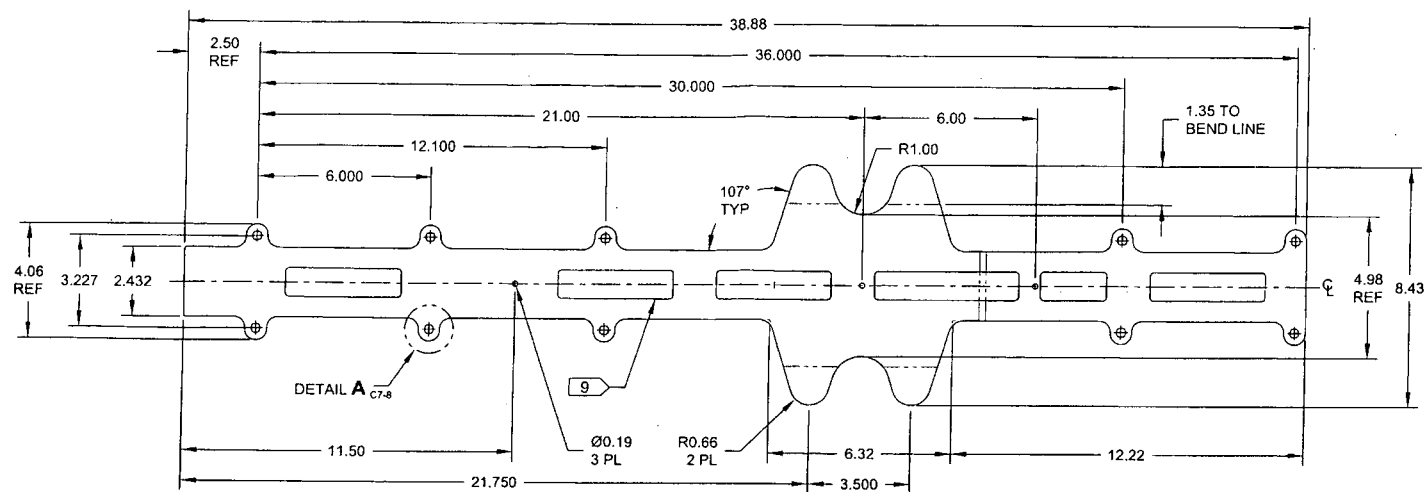
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

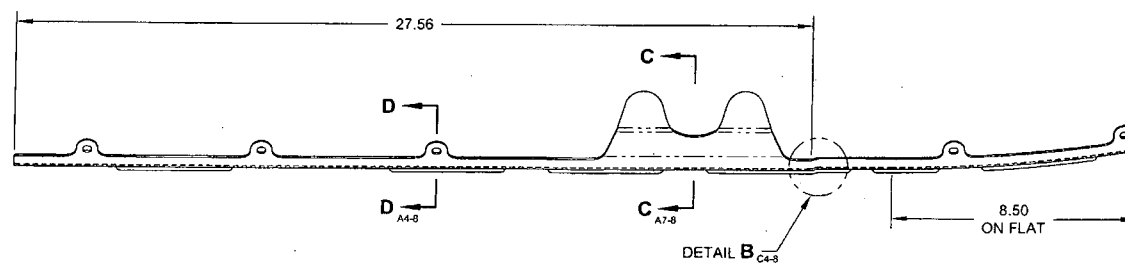
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NOTE: Date & initial all entries



D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

76048

RELEASE
2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 4 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE	NTS
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Dart Aerospace Ltd

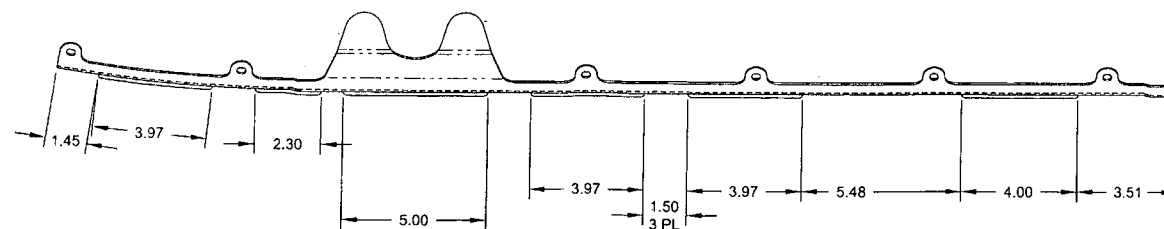
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

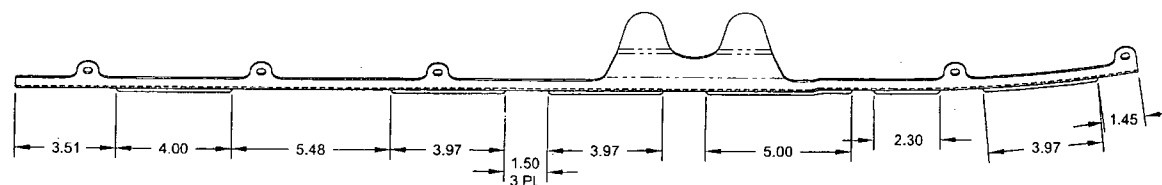
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4095-1 WELDING DETAIL



D4095-3 WELDING DETAIL



76048

RELEASED
2011-10-31
MP

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 5 OF 8
APPROVED	AP	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

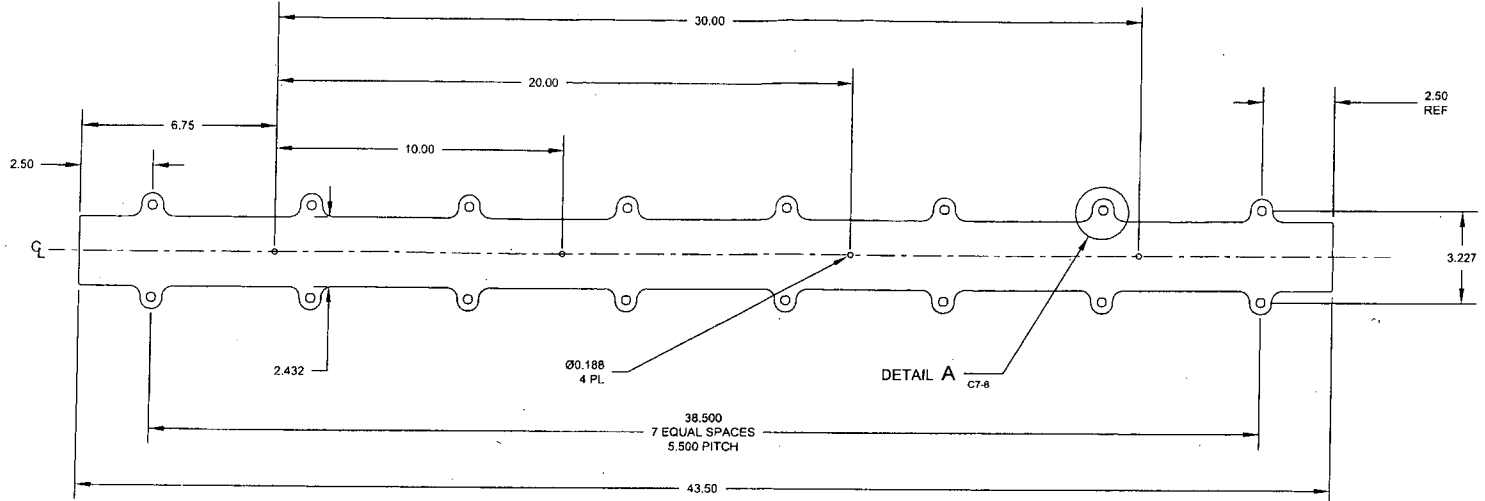
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

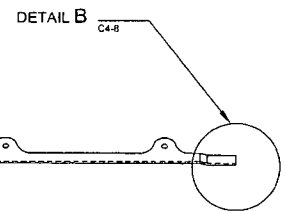
8 7 6 5 4 3 2 1

D

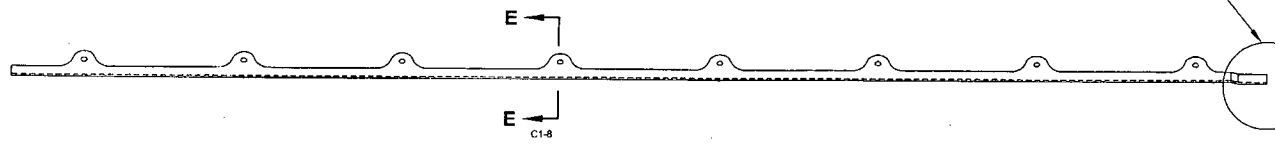


C

D4095-5F FLAT PATTERN 1



B



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

#76048

RELEASED
2011-10-31
MD

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 6 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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8 7 6 5 4 3 2 1

A

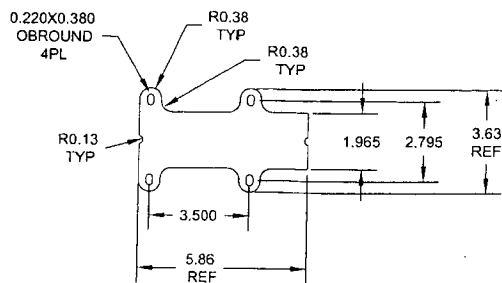
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

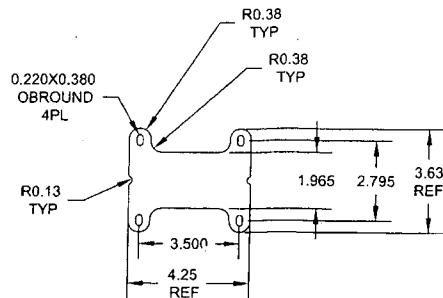
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

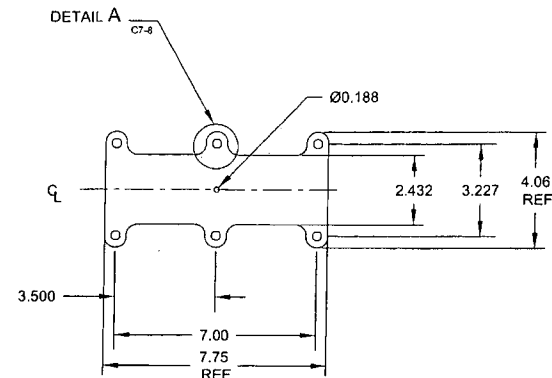
NOTE: Date & initial all entries



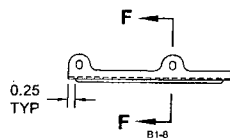
D4095-7F FLAT PATTERN



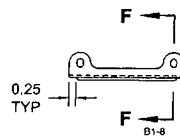
D4095-9F FLAT PATTERN



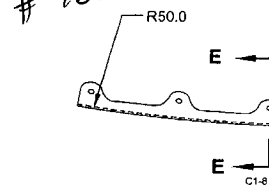
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	110	DRAWING NO.	REV. B
MFG. APPR.	110	D4095	SHEET 7 OF 8
APPROVED	110	TITLE	SCALE
DE APPR.	110	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
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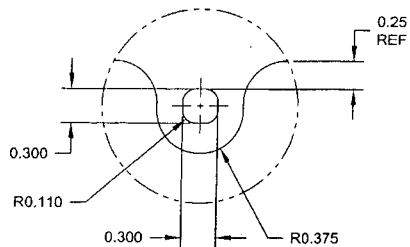
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

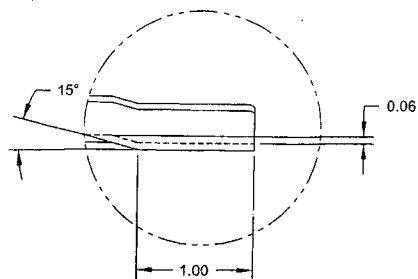
NOTE: Date & initial all entries



DETAIL A: TAB DETAIL

SCALE 4X

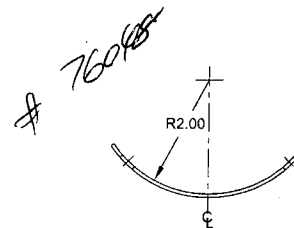
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

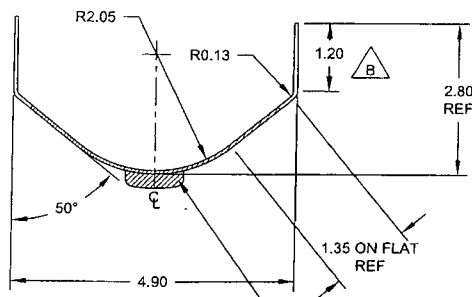
B2-3
B5-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

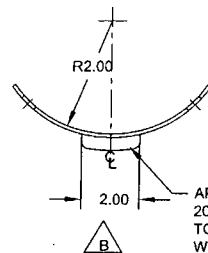


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

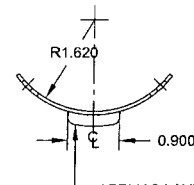


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-3

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 8 OF 8
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries